

Work Order ID 80820

80820

Page 1

March 1, 2012 7:59:09 AM

Item ID: D2596

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Web, 205 Skidtube

Stop

NS2

Start Date: 3/01/12 Start Qty: 8.00

Cust Item ID:

Required Date: 3/05/12 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: CL

Date: 12/03/01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2596	Rev D

100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5"								
	2- Use Jig DT8093 to drill pilot holes #30								
	3- Open to 0.630" diameter as per Dwg D2596								
	4- Deburr								

⑨ H/G 12-3-5

PTO

110	Chemical Conversion Coat per QSI005 4.1	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing									

⑨ H/G 12-3-5 BL

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

9 Ø BE 12-03-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2596 PAR #: _____ Fault Category: Landing Gear/side NCR: Yes No QA: MLJ Date: 12/3/06
 Resolution: scan Disposition: scan QA: N/C Closed: MLJ Date: 12/03/05

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-3-5	100	1 D2500-1-100 cut to short, this read DWG. Short by 1.00" RC; New employee, Training	S 12/3/05 057042	Scrap & replace. B 66298	MLJ 12-3-5	BE 12-03-05	S 12/3/05 057042	S 12/3/05

NOTE: Date & initial all entries

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2596 PAR #: _____ Fault Category: Landing Gear / Side NCR: ☒ Yes ☐ No DQA: MC Date: 12/3/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: MC Date: 12/03/05

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-35	100	1 D2500-1-108 cut to short, this need DWG. Short by 1.00" RC; New employee, Training	S 12/3/05 12/3/05	Scrap & replace. B66298	Wg 12-3-5	BE 12-03-05	S 12/3/05 05/20/12	S 12/3/05

Date & initial all entries

Work Order ID 80820

80820

Page 2

March 1, 2012 7:59:09 AM

Item ID: D2596 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Web, 205 Skidtube
 Start Date: 3/01/12 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/05/12 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LL</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

9 0 BE 12/03/05

MLJ 12/03/05

012-03-5
 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2012 7:59:08 AM

Page 1

Work Order ID: 80820

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 3/01/12

Required Date: 3/05/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	94.0000	1	8			

Ext'n -I' Beam Web 4"

Location

Loc Qty

Loc Code

LG	94
51957	2
66298	23
79041	69

(9) 7/6-12-3-5
(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

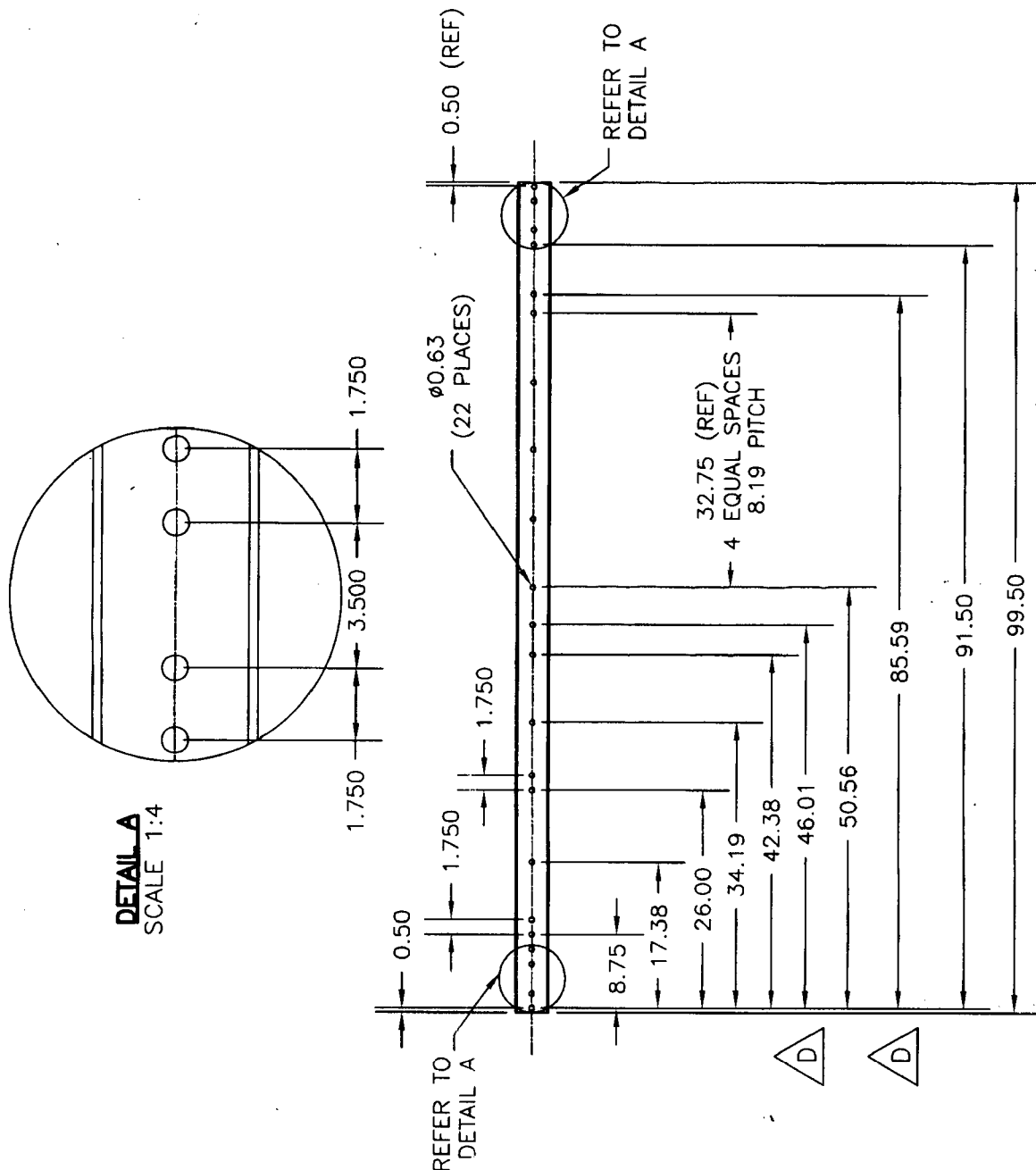
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.18

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

CL 12/03/01
W.D. 80820**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification - Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries